

Work Order ID 109160

Tuesday, November 12, 2013 2:24:43 PM

109160

Page 1

Item ID: D4165-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Rib

Start Date: 11/12/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/14/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *13-11-12*

Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4165	B								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <i>3</i>								
	Prog Rev: <i>3</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

*4 0 Jm 13-11-25**4 0 Jm 13-11-25*

Work Order ID 109160

Tuesday, November 12, 2013 2:24:43 PM

109160

Page 2

Item ID: D4165-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Rib

Start Date: 11/12/2013 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 11/14/2013 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

135

QC3- Inspect Part Finish

0.00

135

QC

Memo

0.00

Quality Control

Work Order ID 109160

Tuesday, November 12, 2013 2:24:43 PM

109160

Page 3

Item ID: D4165-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Rib

Stop ***NS2***

Start Date: 11/12/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/14/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

57206

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

13/11/27

MF

13/11-25

Picklist Print

Tuesday, November 12, 2013 2:24:41 PM

Page 1

Work Order ID: 109160

Parent Item: D4165-5

Parent Item Name: Aft Rib

Start Date: 11/12/2013

Required Date: 11/14/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040

2024-T3 .040 sheet

Purchased

No

100

sf

50.2900

0.58

③

Jm13-11-25

Location

Loc Qty

Loc Code

MAT022

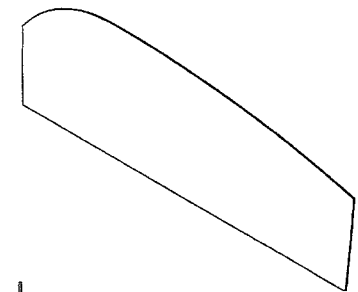
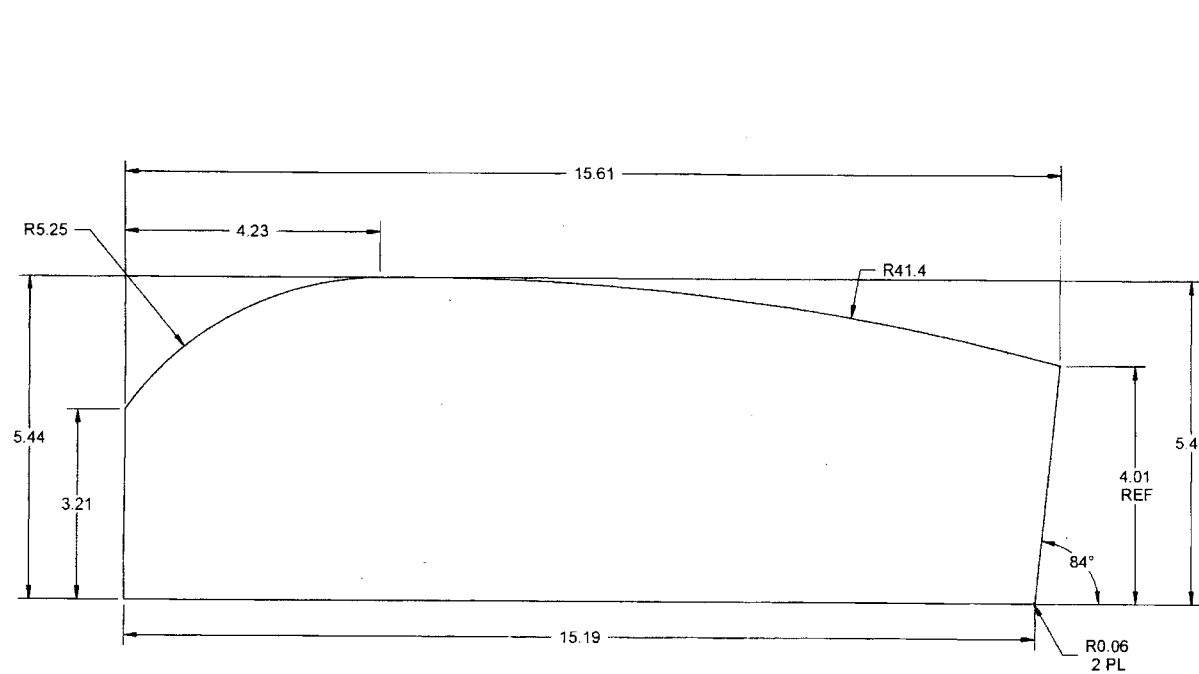
50.2899922

124987

50.2899922

127582

127582.



D4165-5 AFT RIB
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-34)

RELEASED
R 2011-04-15
NP

MF
109160
13-11-12

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.30 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4165	SHEET 3 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	VRD PARTS	NTS
DATE	11.04.11	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

